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Date: Tuesday, 12/09/2006 11:43:28 AM
User: Linda Lacelle

Process Sheet











split B

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CROSSTUBE
Job Number : 28490	
Estimate Number : 10377	
P.O. Number : N/A	Part Number : D2890
This Issue : 12/09/2006 S.O. No. : N/A	Drawing Number : D2890 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/09/2006 Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 23964	Material : N/A
Written By : 	Due Date : 19/09/2006 Qty: 2 Um: Each
Checked & Approved By : _____	
Comment : Est. D 05.03.21 Removed Bending procedures KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
<div><div></div><div></div></div>		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick:		
Qty	Part #	Description
1	D6008-180	Crosstube extrusion
Batch <u>B22534</u> <u>DP 6-11-22</u> ①B		
<u>B22534</u> <u>DP 6-9-26</u> ①A		
2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<div><div></div><div></div></div>		
Comment: HAND FINISHING RESOURCE #1		
ACID ETCH & ALODINE		
25 06 09 26 ①A		
3.0	BENDING	BENDING MACHINE
<div><div></div><div></div></div>		
Comment: BENDING MACHINE		
1-Bend D2890 as per Dwg D2890 and Folio FT002		
<u>DP 6-9-26</u> ①A		
<u>DP 6-11-22</u> ①B		
4.0	QC6	DIMENSIONAL CHECK
<div><div></div><div></div></div>		
Comment: DIMENSIONAL CHECK		
See attached ①A		
5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
<div><div></div><div></div></div>		
Comment: LANDING GEAR RESOURCE 1		
1-Deburr and Polish		
Pm 06-10-10 ①A		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 28490

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

3 N/A
2

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Cor 3/20

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

see W/D 29066

Cor 3/20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①

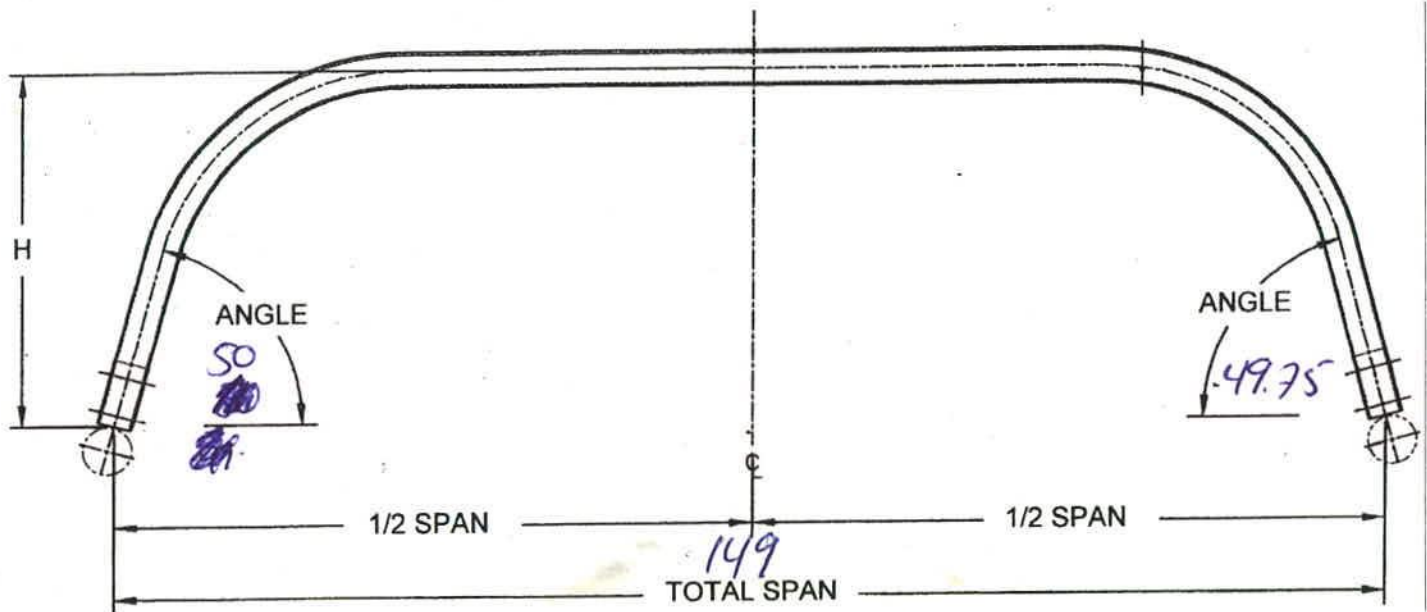
67103/28

Job Completion



u of 3-29

Crosstube Bend Dimension Sheet



See W10 D205-596-103
B29066

PART NUMBER: 2890

BATCH NUMBER: 28490 B

DRAWING: 2890 REVISION: B

H: N/A

1/2 SPAN: N/A

TOTAL SPAN: 138.8[±].25

ANGLE: 50^{±2}

QC 15: J

DATE: 061206

QTY: 1